

Date: Thursday, 04/09/2008 9:01:40 AM  
 Ser: Julie Lecocq

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER  
 Job Number : 41794  
 Estimate Number : 11178  
 P.O. Number :  
 This Issue : 04/09/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D32931  
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3293 REV A  
 Previous Run : 39872 Project Number : N/A  
 Material : A  
 Due Date : 11/09/2008 Qty: 12 Um: Each  
 Written By :  
 Checked & Approved By : 510 08.9.04  
 Comment : Est:A 04.08.24 New issue KJ/JLM  
 Est Rev:B Now on Waterjet 06-11-02 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S080 2024-T3 .080 sheet



Comment: Qty.: 1.9177 sf(s)/Unit Total: 23.0126 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick  
 (M2024T3S.080)  
 Identify for D3293-1  
 Batch: 105411 B 8-9-4

3

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3293  
 Dwg Rev: A B 8-9-4  
 Prog Rev: A  
 2-Deburr if necessary B 8-9-4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

50509/04 B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 04/09/2008 9:01:40 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 41794

Part Number: D32931

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1- Deburr

*u/h Done at step 2.2*  
*50/8/4*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*50/09/04 (X3)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

*JP*  
*08-09-08 (X3)*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*M102316*

START TIME: *10:40am*  
OVEN TEMPERATURE: *320°F*  
FINISH TIME: *11:10am*

*JP*  
*08-09-10 (X3)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FZ*  
*08/09/10 (3)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *211*

*8/9/11*  
*3x*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*JP*  
*08/09/11*

Job Completion



*u 08-09-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



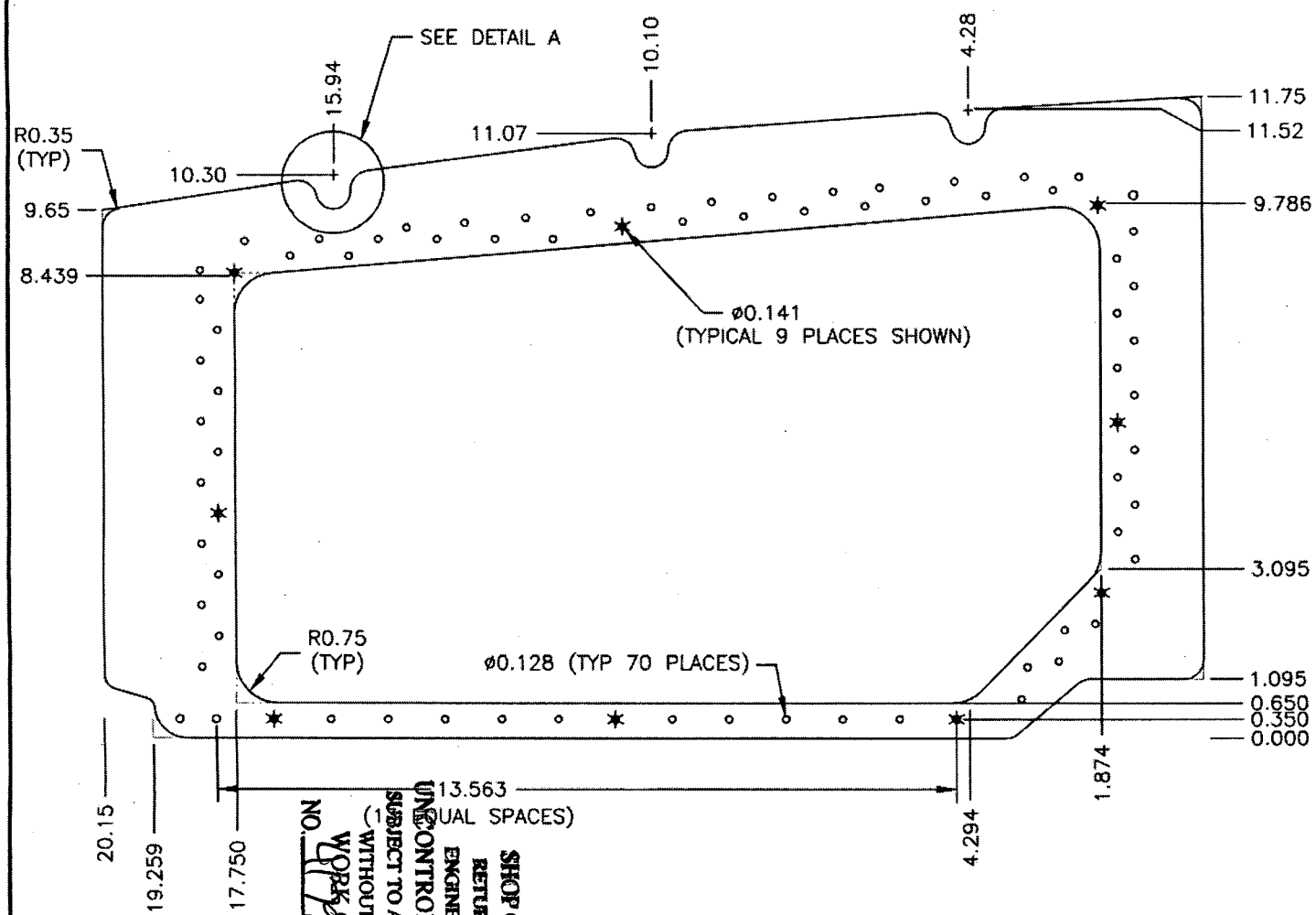
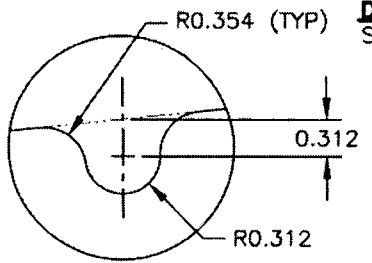


DESIGN		DRAWN BY		DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA					
CHECKED	APPROVED	DRAWING NO.	D3293	REV. A	
DATE	04.06.28	TITLE	DOUBLER	SHEET 1 OF 1	
				SCALE	1:3
A		04.06.28	NEW ISSUE		

D3293-1 DOUBLER  
MAKE PER DRAWING FILE "D3293-A1.DWG"  
CHECK PER TEMPLATE D3293-1T1  
DIMENSIONS SHOWN FOR REFERENCE ONLY  
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER  
DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
04.07.12

DETAIL A  
SCALE 2:3



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